

Work Order ID 50027

July 6, 2009 7:39:23 AM

Page 1

Item ID: D2506

Accept

Revision ID: F

Item Name: Label Plate

Start Date: 08/07/2009 Start Qty: 5.00

Required Date: 17/07/2009 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2506	Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2506 11Dwg Rev: F 11Prog Rev: F 12- => MM 09 07 16 (5)

Deburr if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> MM 09 07 16 (5)

=> MM 09 07 16 (5)

=> Sorlos 17 (5) f

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July 6, 2009 7:39:23 AM

Item ID: D2506

Accept



Setup Start



Revision ID: F

Stop



Item Name: Label Plate

Start Date: 08/07/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 17/07/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

1-Form as per dwg D2506

Debur m. h 09/07/17 (5x)
SP 09/07/20 (5)

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

=> 80% 09/07/20 (5) f

150

0.00



Packaging

Identify as per dwg & Stock Location:

Basket cell

Memo

0.00

Packaging

SY 09/07/20 5x

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Item ID: D2506

Accept



Setup Start



Revision ID: F

Stop



Item Name: Label Plate

Start Date: 08/07/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 17/07/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/2009

MF 09-07-20

Picklist Print

Page 1

July 6, 2009 7:39:22 AM

Work Order ID: 50027



Parent Item: D2506RevF



Parent Item Name: Label Plate

Start Date: 08/07/2009

Required Date: 17/07/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	111.7100	6.4211			



304/316 .040 Sheet



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111.71

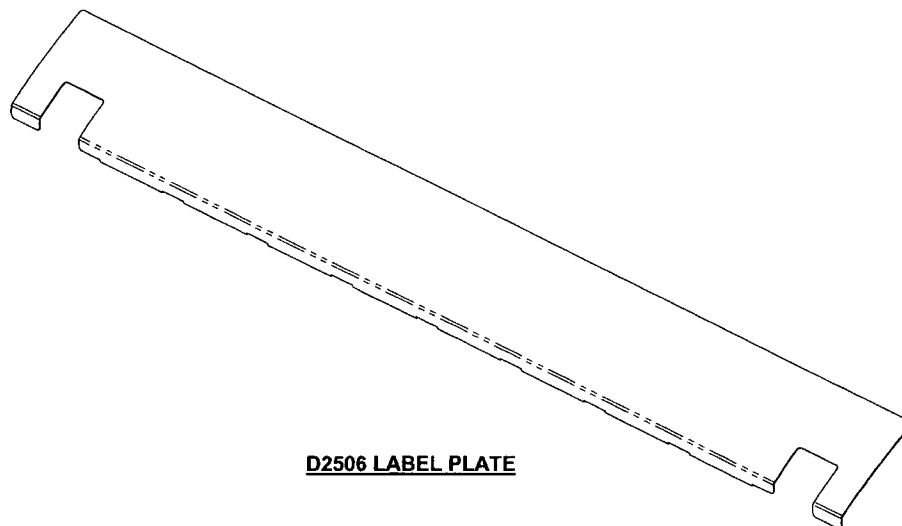
110076

32.79

111571

78.92

ML 09 07 16









D2506 LABEL PLATE

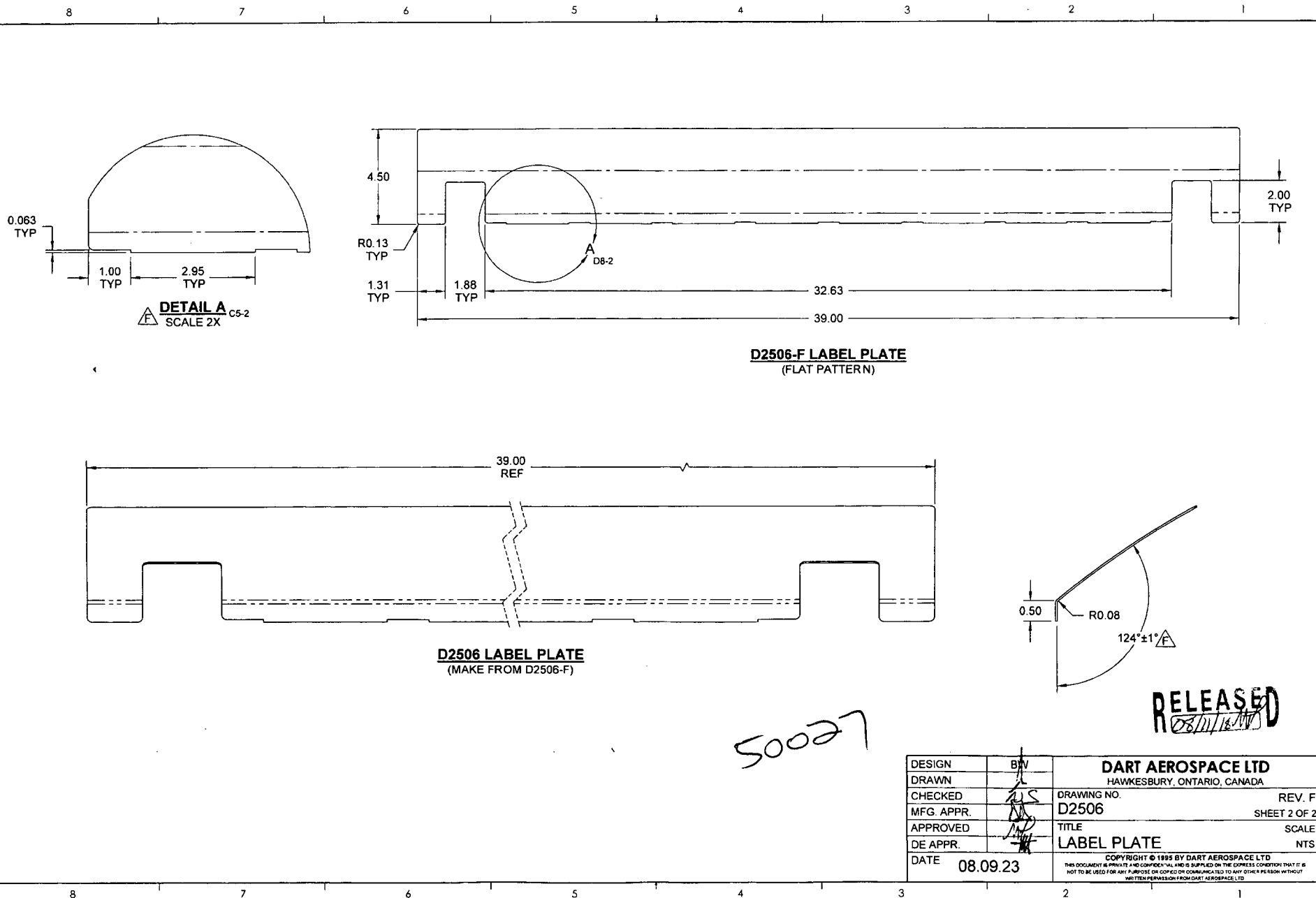
50027

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 
REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.92 lbs

REV.	DESCRIPTION	BY	DATE
F	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT; UPDATED NOTE 1 (ZN A6-1); ADDED DETAIL A (ZN C8-2); 124" ±1" WAS 127" (ZN A4-2). REASONS: EASE MANUFACTURING WITH CORRECTION OF BEND AND ADDITION OF INTERMITTENT WELDING LOCATORS	MB	08.09.23
E	REMOVE 10" BEND; ADD NOTES; 127" WAS 126"	CB	06.11.20
D	32.63 WAS 32.25; 1.31 WAS 1.50	KE	99.10.04
C	RE-DESIGN OF LABEL PLATE	MM	96.09.04
B	RE-DESIGN OF LABEL PLATE	MM	96.06.18
A	NEW ISSUE	KH	95.11.26
DESIGN	B/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2506	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LABEL PLATE	NTS
DATE	08.09.23	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



DESIGN	BRV	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2506	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LABEL PLATE	NTS
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